

Work Order ID 55729

January 29, 2010 8:23:15 AM



Page 1

Item ID:	D2012-117	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Clevis					
Start Date:	1/28/10	Start Qty: 20.00		Cust Item ID:		
Required Date:	2/08/10	Req'd Qty: 20.00		Customer:		

Reference:

Approvals:	Process Plan:	<i>RF</i>	Date:	<i>10-1-29</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2012-117	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2012								
<i>304 1003</i>	Dwg Rev: <i>C</i>								
	Prog Rev: <i>C</i>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

18 10-2-3

EP 10/02/03

(30)

18 10-2-3

⇒ 81062/03

counter
(+30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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January 29, 2010 8:23:15 AM

Page 2

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Setup Start

Revision ID:

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Item Name: Clevis

Start Date: 1/28/10 Start Qty: 20.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form on press using DT8242 as per Dwg D2012-117

0.00

0.00

9/5/02/08 (30)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/02/08

counter
(30)

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

P28

6/14/09 (30)

W/O:		WORK ORDER CHANGES					
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January 29, 2010 8:23:15 AM

Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11

ME

10-2-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:23:23 AM

Page 1

Work Order ID: 55729



Parent Item: D2012-117



Parent Item Name: Clevis

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP: C 99.06.16 Re-format, Now Laser Cut DM
IPP Rev:D Now on WaterJet 07-03-20 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	204.6899	0.2884	5		



304/316 Sheet .063

18 10-2-3

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	204.6898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	141.6049	

113295

30

W/O:		WORK ORDER CHANGES					
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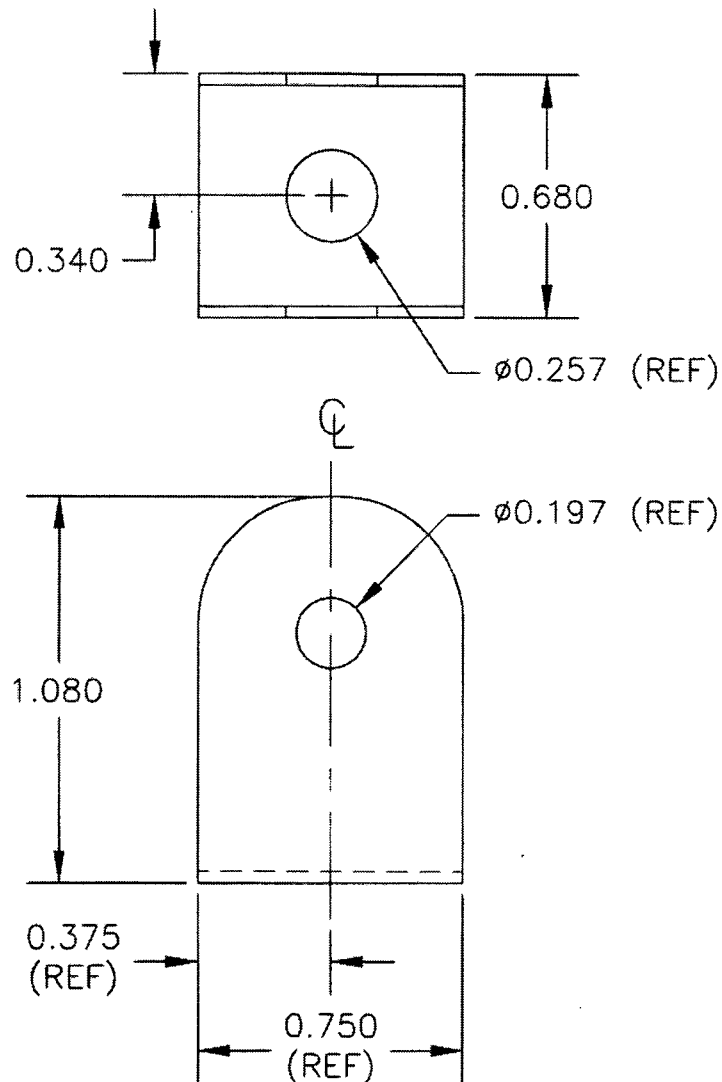
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2012-117	REV. C SHEET 1 OF 2
DATE 99.05.05		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	94.10.27	CHANGED HOLE SIZE, WAS D2012-107	
C	99.05.05	ADD FLAT PATTERN	


RELEASED
99.05.11 KE

6CL55#

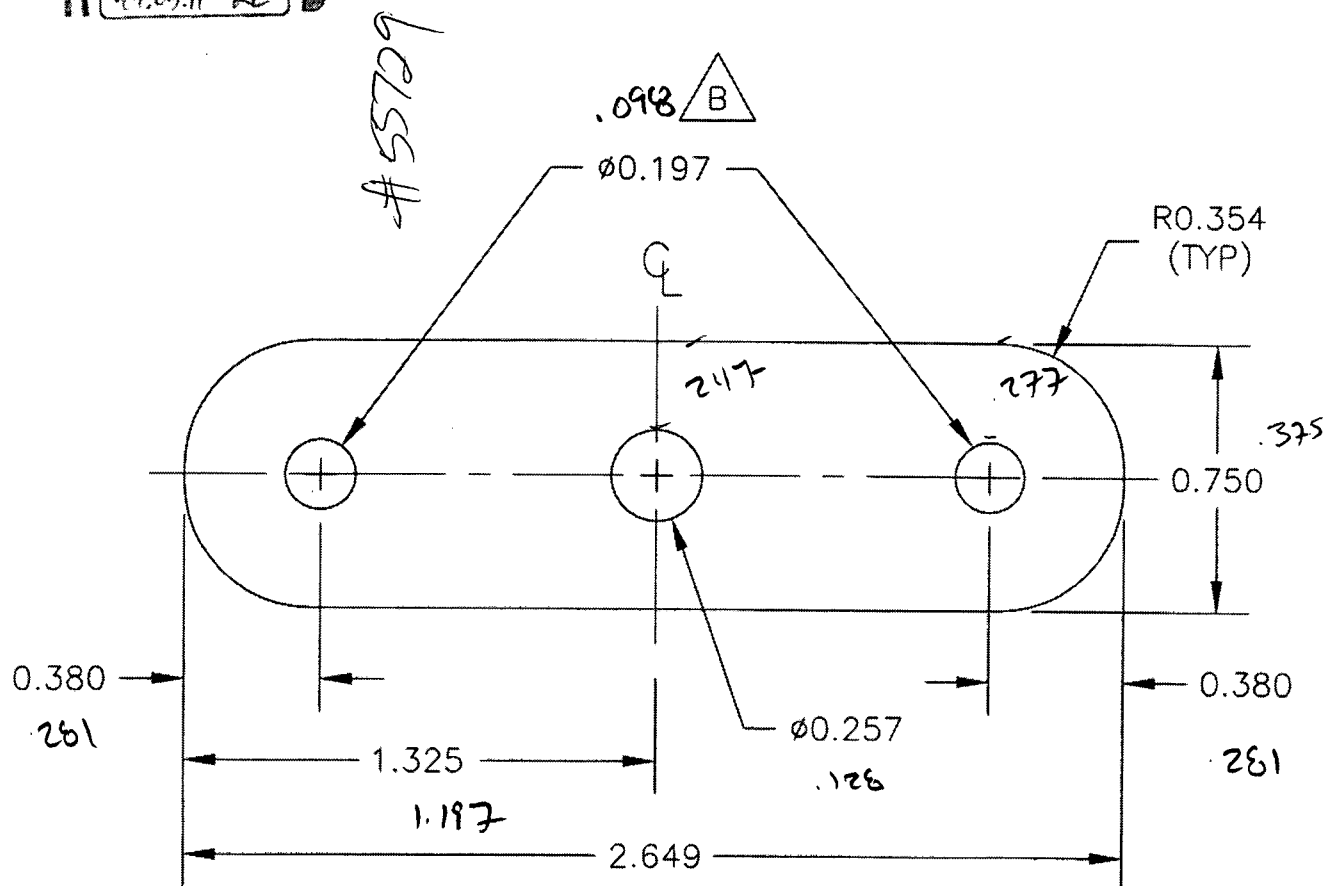


MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2012-117	REV. C SHEET 2 OF 2
DATE 99.05.05		TITLE CLEVIS	SCALE 2:1

RELEASED
99.05.11 KE



D2012-117 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES